

5/45

DART AEROSPACE LTD	Work Order:	24560
Description: Backing plate	Part Number:	D2228
Drawing: D2228 rev. A B	Qty:	100 42


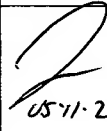
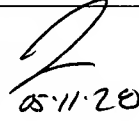

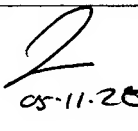
Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	KJ	05.10.13	100 42
2	METAL	Make as per Dwg D2228 Material: 5052-H32 0.063" thick Batch M16454	FF	05/11/14	42 30
3	METAL	Deburr	FF	05/11/17	42
4	QC	Inspect Level 5	J	05.11.20	40 PTO
5	FINISHING	Chemical conversion coat as per QSI 005	DL	05/12/01	40
6	FINISHING	Powder coat white as per QSI 005 (ref. 4.3.5.1)	aim	06/02/20	40
7	QC	Inspect Level 3	FC	06/02/20	40
8	STORES	Identify and stock	5731	6/2/21	40
9	EXPEDITING	Close W/O Cost / part	505 06/02/22 (40)	20/02/22	40

Rev	Date	Change	Revised By	Approved
A				
B	00.08.22	Re-format	EC	

RELEASED

EC 00.08.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-11-28	2	2 parts rivets too wide causing holes to be too far apart		Scrap! destroy	 05-11-28	 05-11-28	 05-11-28	 05-11-28

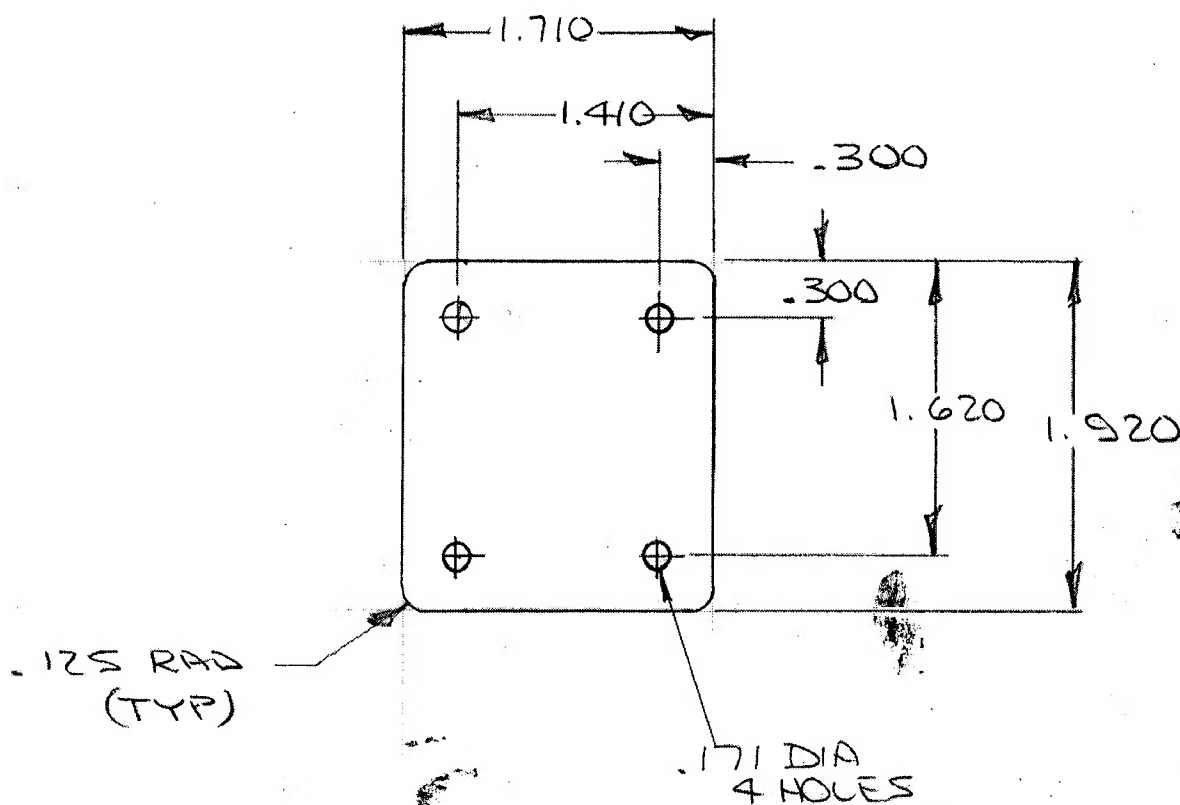
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/02/28

NOTE: Date & initial all entries


QA: N/C Closed: _____ Date: _____

DART

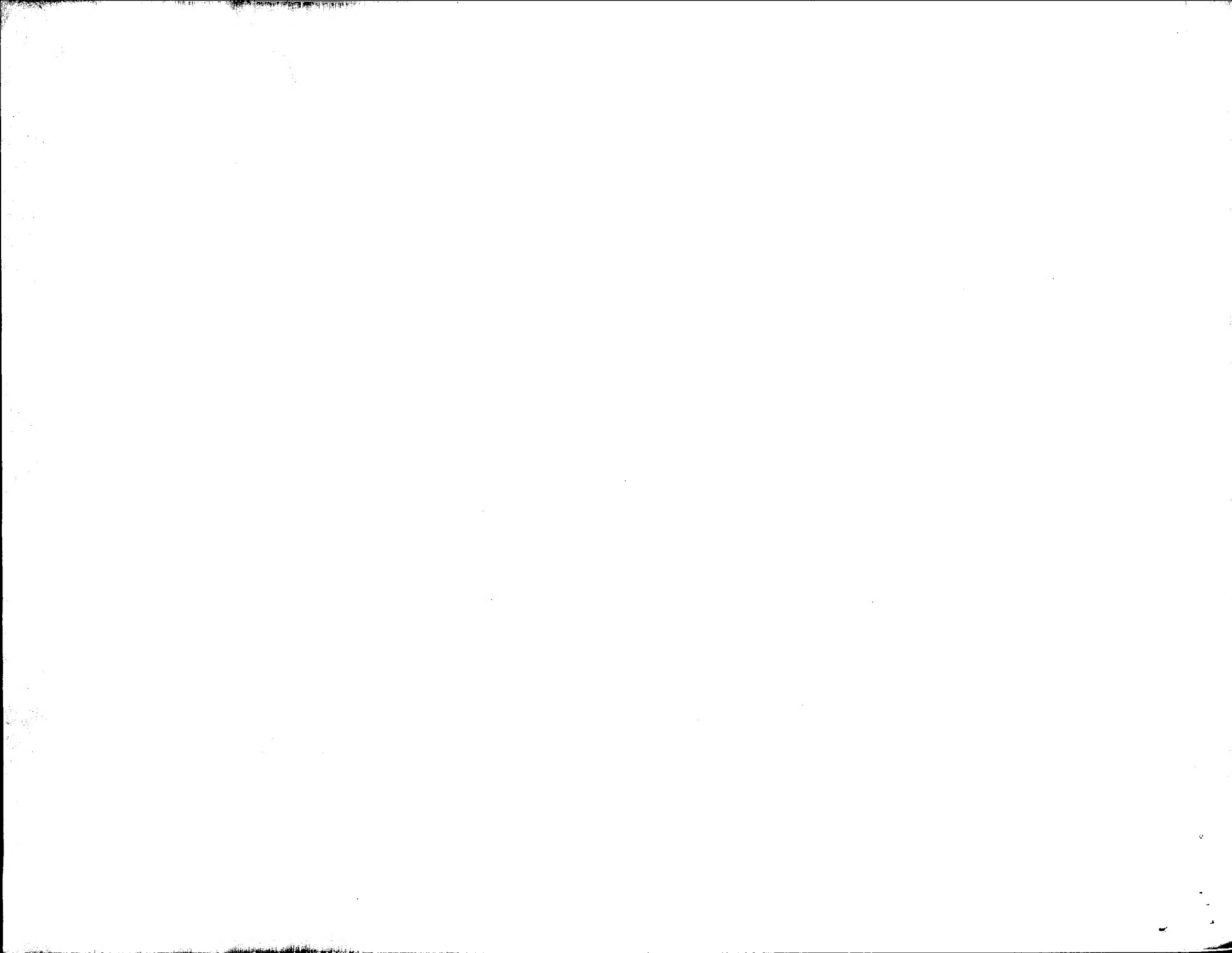
DRAWN BRADLEY 94.3.23		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN BRADLEY 94.3.23		DRAWING NO. D2228	REV. B
STRESS		TITLE BACKING PLATE	
B	00.09.11	UPDATE FINISH SPEC. # UP	

RELEASED
00.04.12 #

MATERIAL : 5052-H 32 .063 THICK
(QQ-A-250/8)

FINISH :  CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

ORDER
NO. 24560



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 13, 2005
11:58 am

Work Order No : 0024560
Project Name : D2228
Project For : WK545
Work Order Type : Main
Main WO Number :
House Part Number : D2228

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Description : Backing Plate
Manufactured : Yes
Amount Req'd : 100 30 42
Amount Done : 0

Order Entry No :
OE Value : 0.00

Start Date : 10-13-05
Est Finish Date : 11-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:23 pm

Work Order No : 0024560
Project Name : D2228
Project For : WK545
Work Order Type : Main
Main WO Number :
House Part Number : D2228
Description : Backing Plate
Manufactured : Yes
Amount Req'd : 30
Amount Done : 0
Start Date : 10-13-05
Est Finish Date : 11-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

MIS 2/15
u
11/15

Date: Monday, 14/11/2005 3:44:54 PM
 User: Alba Panzuto

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BACKING PLATE
Job Number	: 24560		
Estimate Number	: 10506		
P.O. Number	:	Part Number	: D2228
This Issue	: 14/11/2005	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2228 REV. B
First Issue	: / /	Project Number	:
Previous Run	:	Drawing Revision	: B
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 30/11/2005
Checked & Approved By	:	Qty:	30
Comment	: Est:B 00.08.22 Re-format EC	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S063	5052-H32 .063 Sheet
2.0	SHEAR	SHEAR
Comment: SHEAR Cut blank: 1.710" x 1.920"		
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr		
4.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		
6.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		

Date: Monday, 14/11/2005 3:44:55 PM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACKING PLATE

Job Number: 24560

Part Number: D2228

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

